

ABSTRACT OF THE DISCLOSURE

In winding methods, a primary nip formed against a web defines continuing and leading web portions. A secondary nip is formed against and moved along the leading portion, from an outfeed side of the primary nip to an infeed side. The continuing portion and a free end of the leading portion are then
5 simultaneously advanced into the primary nip. Winding apparatus has a winding spindle and builder roller that rotate about parallel winding and builder roller axes, respectively. An axle defines a guide axis and carries a cinch roller that rotates about the guide axis. The axle pivots between first and second orientations, in which the guide axis parallels and is transverse to the winding axis, respectively.
10 The axle moves in the first orientation, in an incomplete orbit about the winding spindle from a start to a rotated position, both adjacent the builder roller, and returns in the second orientation.